

Date: Monday, 3/26/2007 12:16:48 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE ASS'Y
Job Number : 31476	
Estimate Number : 12707	
P.O. Number : N/A	Part Number : D35727
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3572 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 30672	Material : N/A
Written By : <u>EC</u>	Due Date : 4/2/2007
Checked & Approved By : _____	Qty: 4 Um: Each
Comment : Est Rev :A New Issue 07-01-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0053 sf(s)/Unit Total : 0.0105 sf(s) 0.0212
 6061-T6 .080 Sheet
 Batch: M101178 ml 07.03.27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3572
 Dwg Rev: U/R
 Prog Rev: U/R

ml 07.03.27

2-Remove tab only, do not deburr.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

LE 07.03.27

EC 07.03.27

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

FOR ENGINEERING USE ONLY

EC 07.03.27

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Drawing Name: GUIDE ASS'Y

Job Number: 31476

Part Number: D35727

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



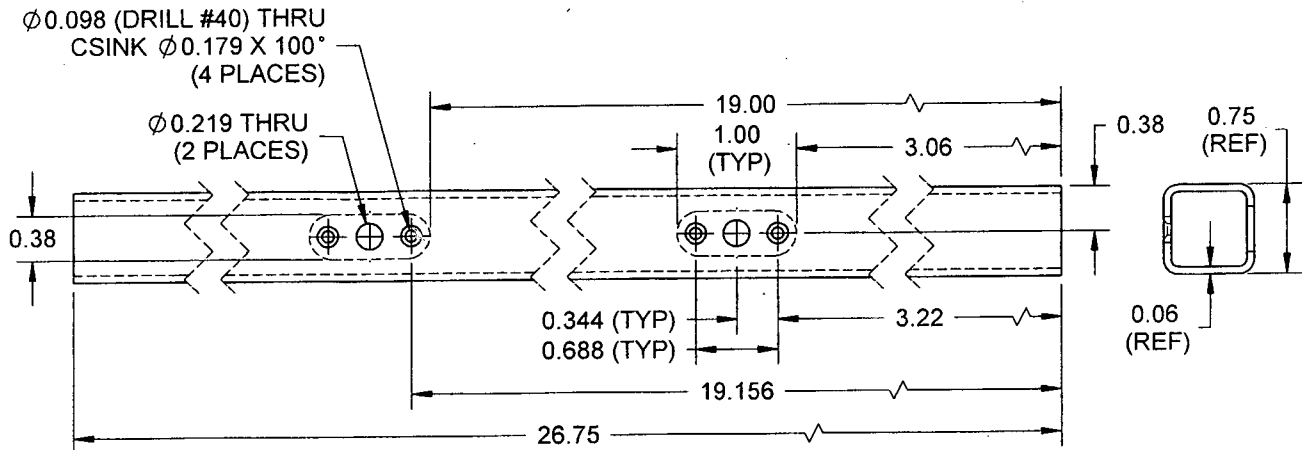
Le 07/03/29

PRELIMINARY ISSUE

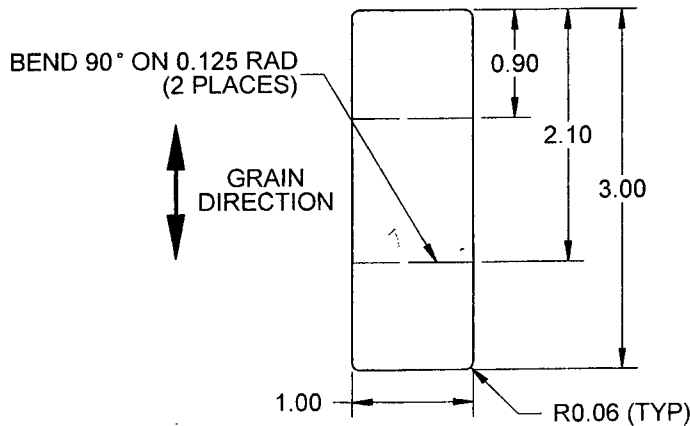
UNDER REVIEW

07.03.21 LE

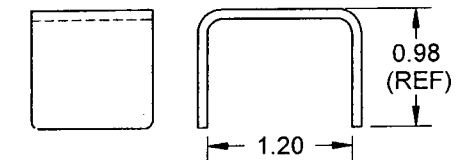
DESIGN LE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.15	TITLE GUIDE ASSEMBLY		SCALE 2:3



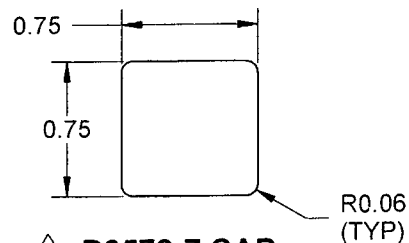
1 D3572-1 TUBE



2 D3572-5F FLAT PATTERN



**D3572-5 BRACKET
(MAKE FROM D3572-5F)**



2 D3572-7 CAP

D3572-1/-5/-7 NOTES:

- 1) MATERIAL: **1** D3572-1: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM SQUARE TUBE 0.750 X 0.062 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160 (REF DART SPEC M6061T6TS0.750W.062)
2 D3572-5/-7: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31476
Description: Guide Assy		Part Number: D3572-1
Inspection Dwg: D3572 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.75	+/-0.030	0.753	✓		VERN	
B	0.75	+/-0.030	0.751	✓		VERN	
C	R0.06	+/-0.030	R0.06	✓		Radius Gauge	
D	0.080	+/-0.010	0.079	✓		VERN	
E							
F							
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: MM. MM	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: 07.03.27	Date: 07.03.27	Date: 07.03.27

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

DOC : V/0080158055

DATUM : 2005-06-14

PROD. REF. : 0000180097/002

NRBST : 63909/01

PAGINA : 1/ 2

PN: 063567

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES
WESTERN REGION MATERIALS
13338 ORDEN DR BLDG H
SANTA FE SPRINGS, CA 90670 USA

UW ORDERNUMMER : PO 4522 (COPPER'S PO # W27358)
ONS ORDERNUMMER : 63909/01
DOCUMENT NUMBER : V/0080158055

Corus Aluminium N.V.
A Sociëteit aan 87, 2570 Duffel - Belgium
Tel 32 (0)15 30 21 11 - Fax (0)15 30 27 94

SPECIFICATIES: ALU SHEETS (STENC.) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X .08"
ARTIKEL NR.:

ROL-
NUMMER

GEUT-
NUMMER

CHEMISCHE ANALYSE (%)

ROL- NUMMER	GEUT- NUMMER	SI	FE	CU	MN	MG	CR	TI	ZN
		MIN 0,40		0,15		0,8	0,04		
		MAX 0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
001	1199501	0,67	0,4	0,20	0,09	1,0	0,15	0,02	0,01

ANDERE : BLK : MIN 0,05 MAX
TOTAAL : MIN 0,15 MAX

TEST-
NUMMER

MECHANISCHE EIGENSCHAPPEN

1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM

TEST- NUMMER	MIN MAX	RM KSI	RP02 KSI	A %
		42	35	10
001	/A	48	41	14
001	/M	48	41	15
001	/V	48	41	15